Tuesday, 04/11/2008 2:03:22 PM Date Melanie Fauteux **Process Sheet Drawing Name** : SQUARE TUBE Customer : CU-DAR001 Dart Helicopters Services Job Number : 43199 - 1 Estimate Number : 13420 : PB6743001207 Part Number P.O. Number : B6743001 P.5/ P.16 : 04/11/2008 S.O. No. **Drawing Number** This Issue : N/A : NC Project Number Prsht Rev. : B1 First Issue : // Type : LARGE FAB ASSY **Drawing Revision** : 42603 Material Previous Run : 11/11/2008 **Due Date** Written By Checked & Approved By 08-06-26 new issue DD verified by:ec Comment : Est Rev:A Additional Product Job Number: Description: Seq. #: Machine Or Operation: 6061T6 SQ TUBE 1.00 x 1.00 X .120w M6061T6TS1000W120 1.0 Comment: Qty.: 9.7346 f(s) 1.9469 f(s)/Unit Total: 6061T6 SQ TUBE 1.00X.120 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 2.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- cut to length as per dwg 2- make a 0.090" chamfer on both ends of tube 3- deburr INSPECT WORK TO CURRENT STEP 3.0 QC5 Comment: INSPECT WORK TO CURRENT STEP CONVENTIONAL MILLING MACHINE 4.0 MILLING CONV Comment: CONVENTIONAL MILLING MACHINE 1- drill holes as per dwg 2- make a 0.090" chamfer (100 degree) on both side of the 4 holes 3- deburr 5.0 QC5 INSPECT WORK TO CURRENT STE

Comment: INSPECT WORK TO CURRENT STEP



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Process Sheet

ner: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

J Number: 43199

Part Number: PB6743001207

Number:



Seq. #: Machine Or Operation:

Description:

6.0

PB6743001225

Bushing

Comment: Qty.:

4.0000 Each(s)/Unit Total:

→ 402 72 → 8

20.0000 Each(s)

7.0

PB6743001223



Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Square Cap B42604+6

8.0

LARGE FAB 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

9.0

SMALL FAB 1

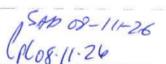
SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr



10.0

QC10



Comment: VISUAL INSPECTION OF GROUND WELDS



11.0

QC5

INSPECT WORK TO CURRENT STEP







Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1









Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 438





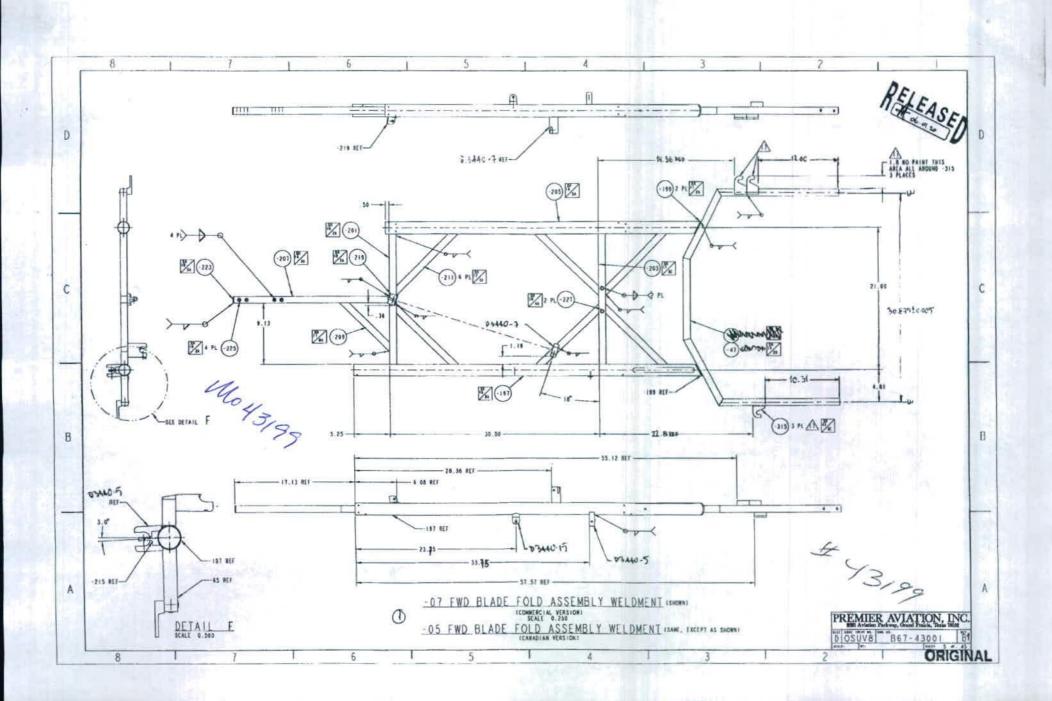
13.0

QC21

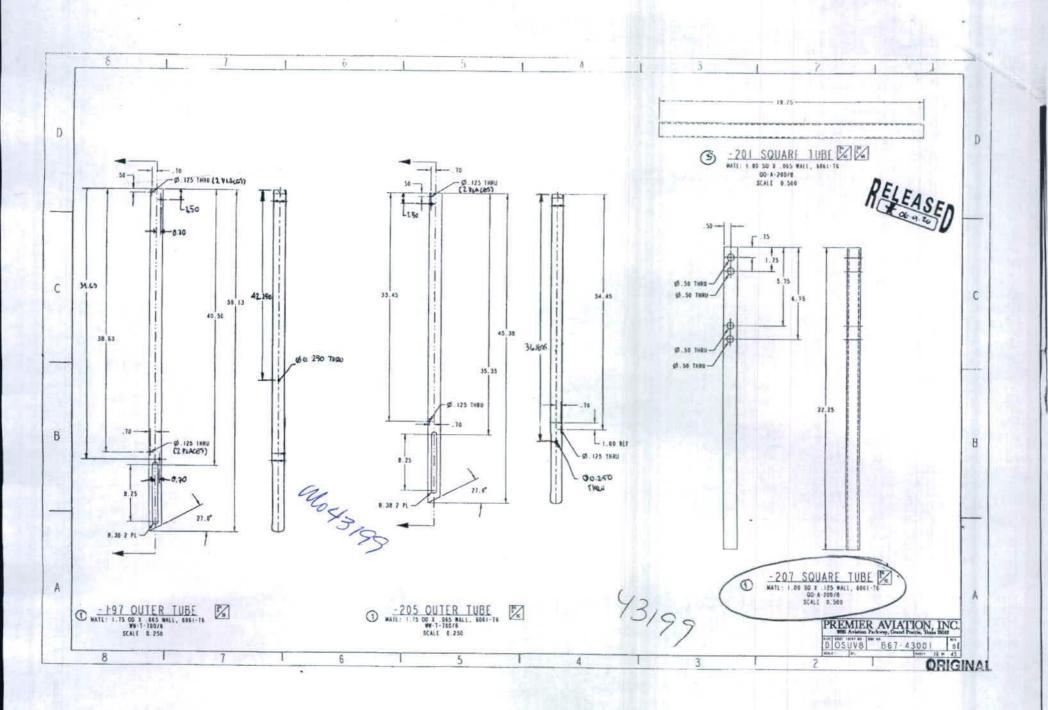
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



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AEROSPACE LTD			Work Order:	43199
	1.		(a) (b)	S-1-1- 1-2
scription: Souare Tube	A.	19	Part Number:	PB6743001207
nspection Dwg: , Rev:				Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	±0.030	0.50	/			
0.75	± 0.030	0.75	1			
1.75	±0,030	1.75	/		The sales	
5.75	+ 0,030	5.75	/			. 1880 1
6.75	± 0,030	6.75	~	2,		v.// : :=
Ø 0.50	±0,030	0.5025	/			X4 places Th
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1	Prototype Approval:	ed by:	Audited by:	200	Measured by:
1.4	Date:	Date: 06 4 24	Date:	08/11/24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

